

# Work Order ID 86166

\*86166\*

Page 1

June-21-12 2:29:50 PM

Item ID: D4016-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Hinge Half, Base

Start Date: 21/06/2012 Start Qty: 18.00 \*18\*

Cust Item ID:

Required Date: 27/06/2012 Req'd Qty: 18.00 \*18\*

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/06/21

Tooling:

Date:

Run Start \*NR1\*

QC: Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center-ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4016

A

100 Cut blanks as per folio

0.00

\*100\*

Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK 1.00" LONG

F.K. 12/07/18

44

Ø

110

0.00

\*110\*

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLIO FA869 AND DWG

FOLIO REV: AB

DWG REV: A

DEBURR

OK 12/07/20

44

Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 QC2- Inspect parts off machine FAI/FAIB

0.00

\*120\*

QC Memo

0.00

Quality Control

130 QC8- Inspect parts - second check

0.00

\*130\*

QC Memo

0.00

Quality Control

160 Identify as per dwg & Stock Location: ST 44 0.00

\*160\*

Packaging Memo

0.00

Packaging

12/07/20

12-07-21

44

10

44X

12-7-23

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Page 3

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Required Date: 27/06/2012 Req'd Qty: 18.00

**\*18\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

170

QC21- Final Inspection - Work Order Release

0.00

**\*170\***

QC

Memo

0.00

Quality Control

12/7/23 *[Signature]*

*mc*  
12-07-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

June-21-12 2:29:55 PM

Page 1

Work Order ID: 86166

**\*86166\***

Parent Item: D4016-1

**\*D4016-1\***

Parent Item Name: Hinge Half, Base

Start Date: 21/06/2012

Required Date: 27/06/2012

Start Qty: 18.00

Required Qty: 18.00

Comments: IPP REV:A NEW ISSUE 09-11-27 JLM VERIFIED BY :DD IPP Rev:B  
as per dwg REV.A DD 10:02:22 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B1.000X1.000		Purchased	No			100	f	34.0270	0.08	1.44			

**\*M304B1 000X1 000\***

**\*\***

304 bar 1.00 x 1.00

Location

Loc Qty

Loc Code

MAT050

34.027

113290

1.047

121806

20.4

122008

12.58

3.52 ~~1.44~~

FK 12/07/18

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	86166
<b>Description:</b> Hinge Half, Base		<b>Part Number:</b>	D4016-1
<b>Inspection Dwg:</b> D4016 <b>Rev:</b> A		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.875	+/-0.010	.876			SLO8	VerN
0.25	+/-0.030	.244			↓	
0.38	+0.030/-0.000	.390				
R0.03	+/-0.030	.030				
0.13	+/-0.030	.125				
0.88	+/-0.030	.878				
Ø0.257	+0.006/-0.001	.259				
R0.38	+/-0.030	.380				
0.500	+/-0.030	.500				
0.75	+/-0.030	.752				

<b>Measured by:</b>	SL	<b>Audited by:</b>	SL	<b>Preliminary Approval:</b>	
<b>Date:</b>	12/07/20	<b>Date:</b>	12-07-21	<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A	10.06.07	New Issue	KJ	

W/O:		WORK ORDER CHANGES					
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SHOP COPY  
RETURN TO  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 86166 M

12/06/21

RELEASED  
2010-02-16  
md

A	NEW ISSUE	JPH	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	GO	DRAWING NO.	REV. A
MFG. APPR.	IS	D4016	SHEET 1 OF 2
APPROVED	NO	TITLE	SCALE
DE APPR.	HT	BASKET HINGE	NTS
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

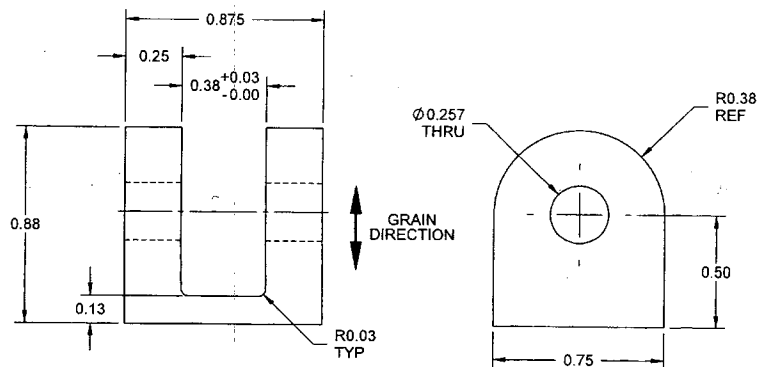
**Dart Aerospace Ltd**

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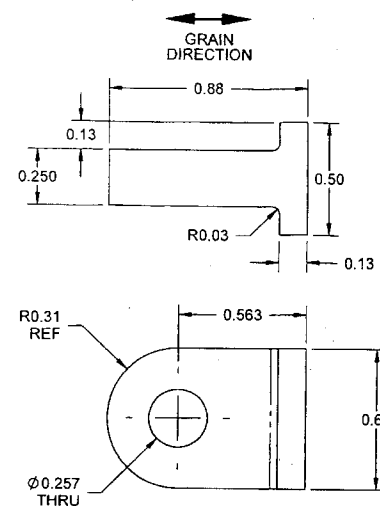
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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**D4016-1 HINGE HALF, BASE**



**D4016-3 HINGE HALF, LID**

**D4016-5 HINGE HALF, LIGHT LID**

**NOTES:**

1) MATERIAL -1 & -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276  
REF DART SPEC M304B

-5: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR,  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6B

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT -1: 0.09 lbs

-3: 0.04 lbs

-5: 0.01 lbs

**RELEASED**  
2010-02-16

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	<b>D4016</b>	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>BASKET HINGE</b>	NTS
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